

RUSH!!  
ASAP

# Work Order ID 72631

Wednesday, August 03, 2011 10:12:08 AM

Page 1

Item ID: D2894-1

Revision ID:

Item Name: 2.750 Support

Start Date: 8/3/2011 Start Qty: 6.00

Required Date: 8/25/2011 Req'd Qty: 6.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 11-08-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2894

Rev D

100



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio FA253  
Tumble & Deburr

0.00

0.00

SL 11-08-09

6

6

110



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

Memo

0.00

0.00

SL 11-08-09

6

6

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

B.A 11/08/09

6

6



**Work Order ID 72631**

Wednesday, August 03, 2011 10:12:08 AM

Page 3

Item ID: D2894-1

Accept

Revision ID:

Item Name: 2.750 Support

Start Date: 8/3/2011 Start Qty: 6.00

Required Date: 8/25/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/18 JF

11-08-11  
(u)

# Picklist Print

Wednesday, August 03, 2011 10:12:14 AM

Page 1

Work Order ID: 72631



Parent Item: D2894-1

Parent Item Name: 2.750 Support

Start Date: 8/3/2011

Required Date: 8/25/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B02.11.26 Added mask hole KJ  
IPP Rev: C ECN 993 07-11-07 DD verified by: EC  
IPP D 08.03.19 Re-format EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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DSK079

Manufactured

No

Each

4.0000

3



2/1/08-10

D2894-1 TURNING DETAIL

Location

Loc Qty

Loc Code

MAT060

4

43976

4

3

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	12631
<b>Description: Ø2.750 Support</b>		<b>Part Number:</b>	D2894-1
<b>Inspection Dwg: D2894</b>		<b>Rev: D</b>	<b>Page 1 of 1</b>

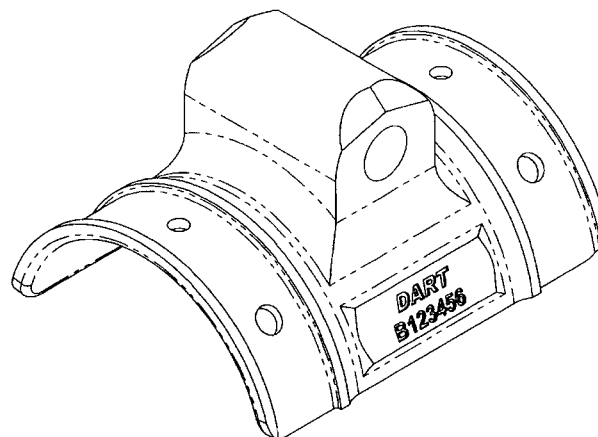
### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5	6
<b>HAAS Section</b>									
AA	0.454	0.474		464	464	465	465	464	464
AB	3.062	3.082		3.072	3.072	3.072	3.072	3.072	3.072
AC	0.053	0.073		063	063	063	063	063	063
AD	1.766	1.786		1.782	1.782	1.775	1.776	1.776	1.776
AE	0.020	0.040		040	040	030	030	030	030
AF	0.260	0.267		262	262	262	262	262	262
AG	0.170	0.190		190	190	180	180	180	180
AH	0.150	0.170		170	170	160	160	160	160
AI	1.990	2.010		1.997	1.998	1.997	1.997	2.005	2.002
AJ	0.240	0.260		250	250	250	250	250	250
AK	1.880	1.900		1.892	1.892	1.892	1.892	1.891	1.893
AL	0.500	0.505		501	501	500	500	500	500
AM	0.188	0.194		189	189	189	189	189	189
<b>Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"</b>									
<b>Accept/Reject</b>				003	003	001	002	003	001

<b>Measured by:</b>	JL	<b>Date:</b>	11-08-09
<b>Audited by:</b>	B. A	<b>Date:</b>	11/08/09
<b>Prototype Approval:</b>		<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	08.04.22	Reformat; Dwg Rev updated	KJ/DD	
E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	
F	09.05.04	Dimension AN (0.926) removed	KJ/JLM	



**D2894-1 Ø2.750 SUPPORT**

**RELEASED**  
8/11/06

*WLB 72631*

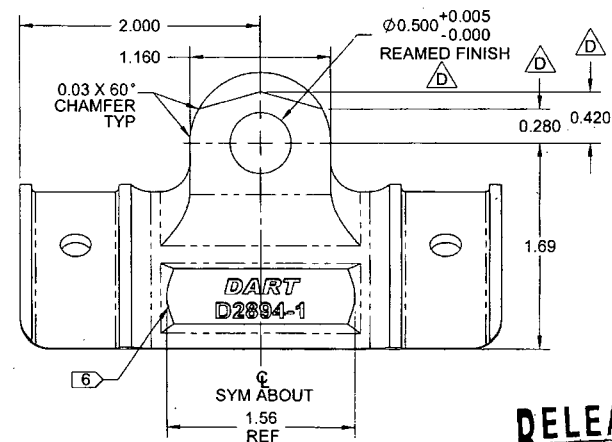
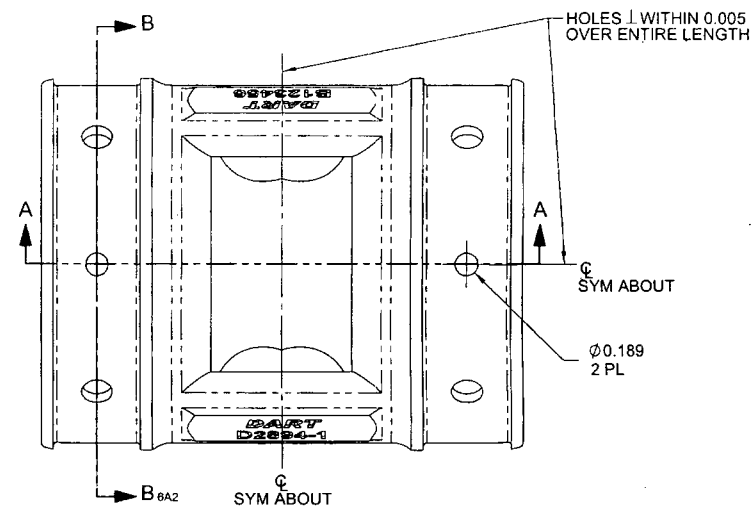
**NOTES:**

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRC)
- 2) FINISH: PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2 D
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) 0.50" WIDE x 1.56" LONG x 0.005" MIN HEIGHT FLAT,  
WITH R0.25 RADIUS OF TRANSITION IN THIS AREA  
IDENTIFY WITH DART LOGO AND PART NUMBER ON ONE  
SIDE AND DART LOGO AND BATCH NUMBER ON OPPOSITE  
SIDE USING 0.010-0.020 DEEP LETTERING
- 7) WEIGHT: 0.98 lbs

D	DRAWING REFORMATTED. POWDER COAT FINISH REMOVED. CHAMFERS ADDED TO TOP OF PART TO CLEAR ROCKER BEAM. PER BELL TECH BULLETIN 407-08-84. B5-2 0.281 HOLE WAS 0.257. B2-2 REAM FINISH INSTRUCTION ADDED.	AJS	08.11.06
C	ADD MASKING AND PRIME ONLY NOTES, REFORMATTED DRAWING.	DC	07.07.04
B	AS MANUFACTURED	CP	02.07.17
A	NEW ISSUE	CP	02.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2894	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		Ø2.750 SUPPORT	NTS
DATE	08.11.06	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	


**SECTION A-A**

**SECTION B-B** C3-2  
(VIEW ROTATED 90°)



**D2894-1 Ø2.750 SUPPORT**

RELEASED  
2011/19 NW

DESIGN	DS		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		DRAWING NO.	REV. 1
CHECKED			D2894	SHEET 2 OF 2
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DATE	08.11.06			